

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018212**Date Inspected:** 19-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Min**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Subassembly**Summary of Items Observed:**

On this day CALTRANS Office of Structural Materials (OSM) Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG BAY 8

This QA observed ZPMC qualified welding personnel identified as 040736 perform Flux Core Arc Welding (FCAW) on Bike Path components. The weld joint is identified as BK004A3-062-025. ZPMC QC Mr. Liu Fa Wen was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

OBG BAY 7

This QA observed ZPMC qualified welding personnel identified as 205386 perform Flux Core Arc Welding (FCAW) on Barrier Rail components. The weld joint is identified as W2-SB9-069-113. ZPMC QC Mr. Shen Jian Guo was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P4-F.

This QA observed ZPMC qualified welding personnel identified as 067447 perform Flux Core Arc Welding (FCAW) on Barrier Rail components. The weld joint is identified as W2-SB9-069-114. ZPMC QC Mr. Shen Jian

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Guo was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P4-F.

This QA observed ZPMC qualified welding personnel identified as 053742 perform Flux Core Arc Welding (FCAW) on Barrier Rail components. The weld joint is identified as W2-SB10-038-126. ZPMC QC Mr. Shen Jian Guo was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P4-F.

OBG BAY 6

This QA observed ZPMC personnel heat straightening Orthotropic Box Girder (OBG) deck panel identified as DP3168B-001, weld joints 098, 099, 103, 104, 106, 107, 109, 110, 112, 113, 115, 116, 123, 139, 137, 138, 139, and 140. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Li Jia was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR1 (B)-0433.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
